



Dart Aerospace Ltd.
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K6A 1K7
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D2565-103
Job Sheet 209653



Part No: D2565-103

Job Qty: 4 pcs

Part Name: Strut



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/5/20

Job Tracking No:

Due Date: 5/27/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV E IPP: F 02.04.16 Added dwg Rev.C1 NG

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - Brake NC 18.460	4 pcs	5/26/20	5/26/20	0.25	0.52	Small Fab - Brake - 1		58 9-89
							Small Fab - Brake - 2		
							Small Fab - Brake - 3		
120	QC 5	4 pcs	5/26/20	5/26/20	0.00	0.00	QC 5 - 10		MAY 12 2020 40 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
							QC 5 - 82		
130	Powdercoat - 2 White Gl(S)- B4B M 254 469	4 pcs	5/27/20	5/27/20	0.00	0.10	Powdercoat - 1 - B4B		20-05-14 33 34 9-89
							Powdercoat - 2 - B4B		
							Powdercoat - 3 - B4B		
							Powdercoat - 4 - B4B		
140	QC 3	4 pcs	5/27/20	5/27/20	0.00	0.00	QC 3 - 10		M 20-5-15 DAS 15 9-89
							QC 3 - 13		
							QC 3 - 15		
							QC 3 - 17		

Plex 5/5/20 9:40 AM Dart.Renwick.Jennife

				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	
				QC 3 - 87	
150	Packaging 3-1 - Stock - B4B	4	5/27/20	0.00 0.00	Packaging 3 - 1 - B4B
		pcs			Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 -

DAS
28
9-89

				B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
160 QC 21 - SA	4 pcs	5/27/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	MAY 19 2020 70
				QC 21 - SA - 53	

Part Op **100** - 1- Punch to length as per Dwg D2565 using DT8313 2-Drill hole open to .316 Ø as per Dwg D2565 (one end only)

Descriptions: **120** - QC5- Inspect part completeness to step on W/O

130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel START TIME: _____ FINISH TIME: _____

140 - QC3- Inspect Part Finish

150 - Identify as per dwg & Stock Location: _____

160 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304TR0.750W.049	304 Round Tube .750 X .049W	6.0700 ft (1.5175 ea)	100-Small Fab - Brake NC	5069180

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - Brake NC	M304TR0.750W.049	6	388	0

Part Specifications
Specifications could not be found.

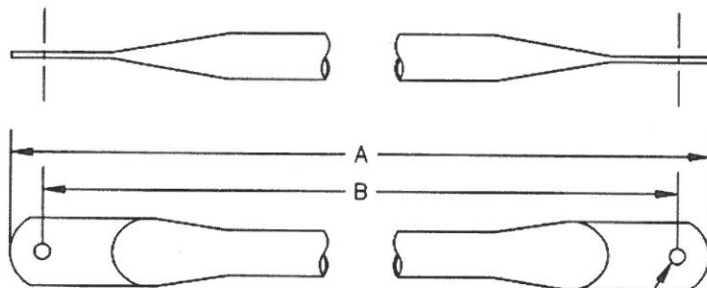
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED
04.05.05

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 209653



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Eng. (Non-AW) ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Finishing ☐ Rec/Store/Packaging ☐		Skid-tube ☐ Machining ☐ Large Fab ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																																																																																	
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042)																																																																																			
Description Work Order Deviation				Disposition																																																																																					
Root Cause <table border="1"> <tr> <td>Operator</td><td>☐</td> <td>Pressure/Forced</td><td>☐</td> <td>Contamination</td><td>☐</td> <td>Power Loss/Surge</td><td>☐</td> <td>Positioned Wrong</td><td>☐</td> </tr> <tr> <td>Manufacturing Process</td><td>☐</td> <td>Bending</td><td>☐</td> <td>Misaligned/off center</td><td>☐</td> <td>Folio/Program</td><td>☐</td> <td>Outside Tolerance</td><td>☐</td> </tr> <tr> <td>Equip/Tooling</td><td>☐</td> <td>Crushing</td><td>☐</td> <td>BOM/Route</td><td>☐</td> <td>Grain Direction</td><td>☐</td> <td>Drawing</td><td>☐</td> </tr> <tr> <td>Handling/Preservation</td><td>☐</td> <td>Cracks</td><td>☐</td> <td>Broken/Damage/Defect</td><td>☐</td> <td>Weld</td><td>☐</td> <td>Finish</td><td>☐</td> </tr> <tr> <td>Material</td><td>☐</td> <td>Crimp/Kink/Ripple/Wave/Twist</td><td>☐</td> <td>Incomplete/Unclear Instructions</td><td>☐</td> <td>Wrong Stock Pulled</td><td>☐</td> <td>Part Lost/Missing</td><td>☐</td> </tr> <tr> <td>Product Improvement</td><td>☐</td> <td>Marks/Chatter</td><td>☐</td> <td>Drill Holes</td><td>☐</td> <td>Out of Sequence</td><td>☐</td> <td>Misread</td><td>☐</td> </tr> <tr> <td>Process Improvement</td><td>☐</td> <td>Mislabeled</td><td>☐</td> <td>Fit/Function</td><td>☐</td> <td>Off-set/Set-up</td><td>☐</td> <td></td><td></td> </tr> <tr> <td>Human Factors</td><td>☐</td> <td colspan="8">Other/Details: _____</td> </tr> </table>										Operator	☐	Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Manufacturing Process	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐	Equip/Tooling	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐	Handling/Preservation	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐	Material	☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Product Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐	Process Improvement	☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐			Human Factors	☐	Other/Details: _____							
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